

Date: Thursday, 19/03/2009 11:06:50 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 46596	
Estimate Number : 12900	
P.O. Number :	Part Number : D35089
This Issue : 19/03/2009 S.O. No. :	Drawing Number : D3508 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 40359	Material :
Written By :	Due Date : 03/04/2009 Qty: 4 Um: Each
Checked & Approved By : <u>Jul 09-03-19</u>	
Comment : Est Rev:A New Issue 07.06.12 EC	
Est Rev:B Rev C dwg 07-12-06 DD	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304S20GA

304/316 .040 Sheet



Comment: Qty.: 0.4379 sf(s)/Unit Total : 1.7514 sf(s)

304 SS .038" THK (20GA)

(M304S20GA)

Batch: 10076

ml 09.03.25

(4)

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3508

Dwg Rev: CProg Rev: C

2-Deburr if necessary

ml 09.03.25

(4)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



ml 09.03.25

(4)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.03.25 (K4)

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr and form on brake using DT8326 and DT8261 as per Dwg D3508

5.03.25 (K4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 11:06:50 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 46596

Part Number: D35089

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 02/03/31 (X4)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M/09648

START TIME:

10:30

OVEN TEMPERATURE:

320°

FINISH TIME:

11:00

BR 09-04-2

(X4)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

09-04-02

(X4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-21

21/

09-04-02

(X4)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/03

Job Completion



MF

09-04-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	46596
Description: Wearplate		Part Number:	D3508-9
Inspection Dwg: D3508 Rev: C		Page 1 of 1	

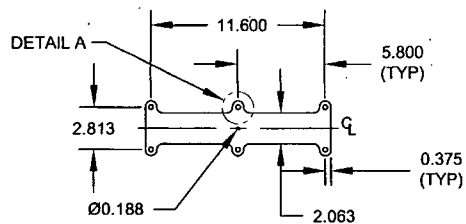
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

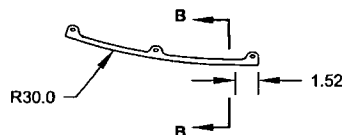
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.063	+/-0.010	2.068	✓		vern	
2.813	+/-0.010	2.814	✓		vern	
0.375	+/-0.010	0.376	✓		vern	
2.90	+/-0.030	2.90	✓		vern	
5.800	+/-0.010	5.802	✓		vern	
11.600	+/-0.010	11.600	✓		M.T	
17.400	+/-0.010	17.400	✓		M.T	
Ø0.188	+0.005/-0.001	0.188	✓		vern	
0.300	+/-0.010	0.300	✓		vern	
0.300	+/-0.010	0.300	✓		vern	
0.038	+/-0.010	0.039	✓		vern	

Measured by:	ml, ml	Audited by:	S	Prototype Approval:	N/A
Date:	09.03.25	Date:	09.03.25	Date:	N/A

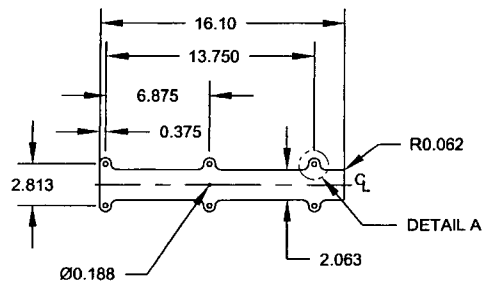
Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD	AS



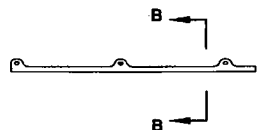
D3508-1 FLAT PATTERN



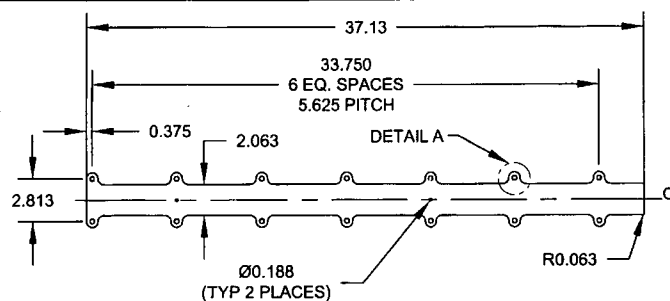
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



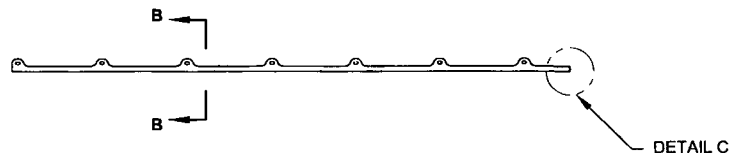
D3508-7F FLAT PATTERN



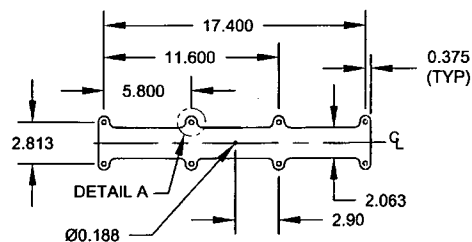
D3508-7F BENDING DETAIL
(MAKE FROM D3508-7F)



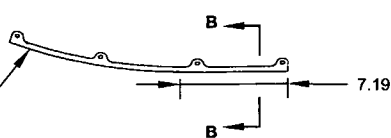
D3508-3 FLAT PATTERN



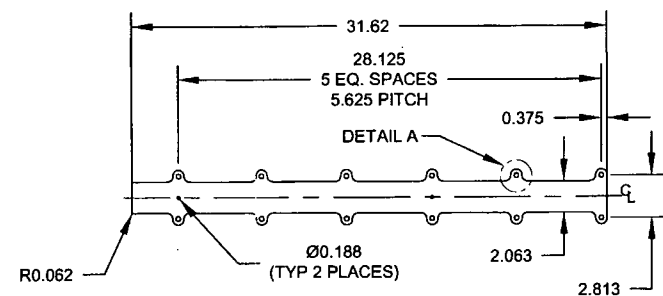
D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



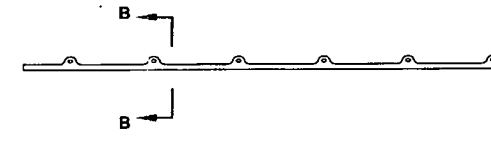
D3508-9F FLAT PATTERN



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)



D3508-5 FLAT PATTERN



D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)

NOTES:

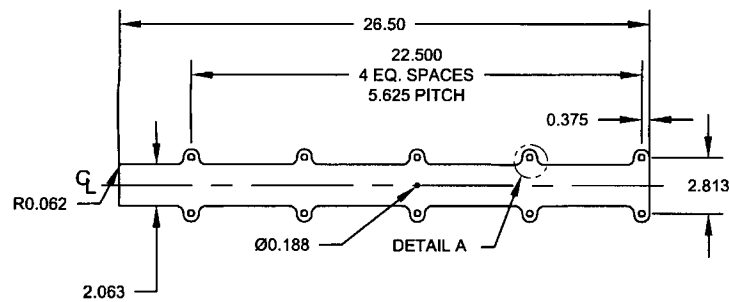
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs
D3508-13 - 0.25 lbs

RELEASED
07.11.16

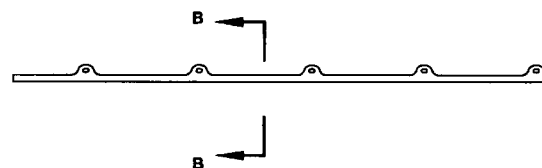
NO WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
RETURN TO
ENGINEERING
380
SHOP COPY

C	ADD -9/11/13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE

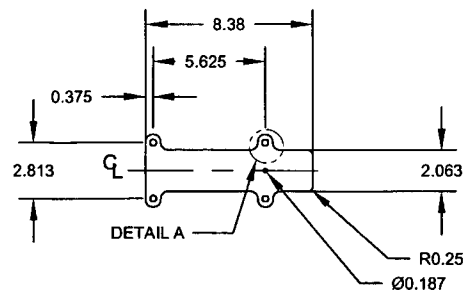
DESIGN	<i>244</i>	DART AEROSPACE USA, INC	
DRAWN	<i>244</i>	PORT HADLOCK, WA	
CHECKED	<i>MD</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>MD</i>	D3508	SHEET 1 OF 2
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>MD</i>	WEARPLATE	1:
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



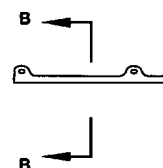
D3508-11F FLAT PATTERN



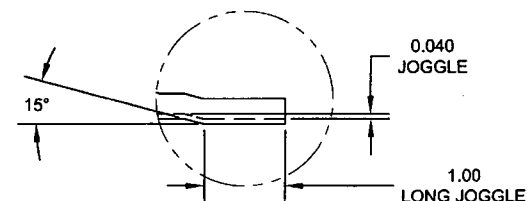
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



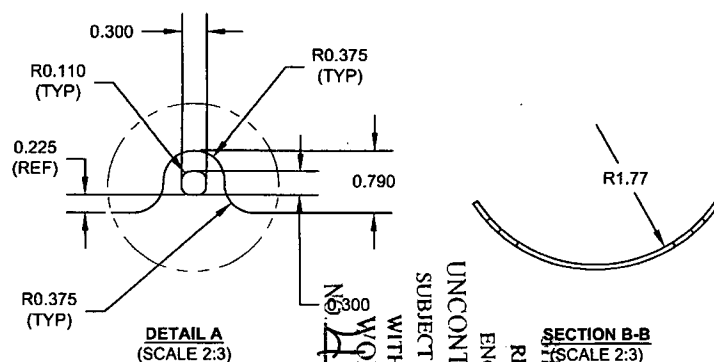
D3508-13F FLAT PATTERN



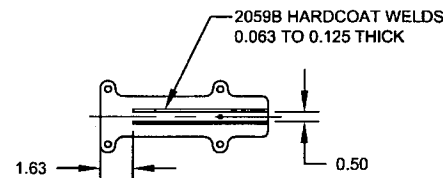
D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



DETAIL C
(SCALE 1:2)



DETAIL A
(SCALE 2:3)



D3508-13 WELDING DETAIL

RELEASED
07-11-14

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DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3508	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARPLATE	1:6
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